Wednesday, 6/6/2007 1:47:33 PM Date Kim Johnston User **Process Sheet** : LUG BRACKET Customer : CU-DAR001 Dart Helicopters Services **Drawing Name** : 32770 Job Number **Estimate Number** : 10009 :NA : D27351 Part Number P.O. Number S.O. No. : NA D2735 REV C : 6/6/2007 **Drawing Number** This Issue : N/A Project Number Prsht Rev. MA : SMALL /MED FAB **Drawing Revision** Type First Issue :NA : 32581 Material Previous Run Each : 6/22/2007 **Due Date** Written By Checked & Approved By JLM Removed from 9 Digit 05-10-25 Comment 06.09.19 EC waterjet est rev D Additional Product Job Number: Machine Or Operation: Description: Seq. #: . M1010S125 1010-1025 sheet .125 1.0 Comment: Qty... 0.1733 sf(s)/Unit Total: 5.1975 sf(s) 1010-1025 sheet .125 M104699 FLOW WATER JET WATER JET 2.0 Comment: FLOW WATER JET 1-Cut as per Dwg D2735 (D2735-1) Dwg Rev:_ Prog Rev:___ 2-Deburr if necessary 3.0 QC2 SAD) Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK 4.0 QC8 Comment: SECOND CHECK NC BRAKE 5.0 BRAKE NO Comment: NC BRAKE 07/04/27 1-Form D2735-1 as per Dwg D2735. Use CNC Brake Jig DT8204 2-Deburr if required.

Dart Aerospace	∟ıa
----------------	-----

W/O:		WORK ORDER CHANGES						
DATE STEE		PROCEDURE CHANGE				Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No:	PAR :	#: Fault Category:	NCR: Yes No DQA	: Date: 0406/0
			QA: N/C Closed	: Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section E		Verification	Approval Chief Eng	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Approval QC Inspecto	

NOTE: Date & initial all entries

Wednesday, 6/6/2007 1:47:33 PM Date: Kim Johnston User: **Process Sheet** Drawing Name: LUG BRACKET Customer: CU-DAR001 Dart Helicopters Services Job Number: 32770 Part Number: D27351 Job Number: Description: Seq. #: **Machine Or Operation:** INSPECT WORK TO CURRENT STEP 6.0 QC5 Comment: INSPECT WORK TO CURRENT STEP PACKAGING 1 PACKAGING RESOURCE #1 7.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 8.0 QC21 07/06/29 Comment: FINAL INSPECTION/W/O RELEASE W Freda. 28 Job Completion

rospace Lt	:d								
		WC	ORK ORDER CH	ANGES				· · · · · · · · · · · · · · · · · · ·	
STEP	PR	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							-		
:	PAR #:	Fault Cate	gory:	NC					
		WORK ORD	ER NON-CONFO	RMANCE			u:	Date:	
STEP Description of NC Initial		Action Descrip	Section B				Approval Chief Eng	Approval QC Inspector	
	STEP :	:PAR #:	STEP PROCEDURE CHA : PAR #: Fault Cate WORK ORD STED Description of NC	WORK ORDER CH STEP PROCEDURE CHANGE PAR #: Fault Category: WORK ORDER NON-CONFO STEP Description of NC Corrective Action Corrective Corrective Action Corrective Cor	WORK ORDER CHANGES STEP PROCEDURE CHANGE :PAR #:Fault Category:NC WORK ORDER NON-CONFORMANCE WORK ORDER NON-CONFORMANCE STEP Description of NC Section A Corrective Action Section B Initial Action Description	WORK ORDER CHANGES STEP PROCEDURE CHANGE By : PAR #: Fault Category: NCR: Yes QA: N WORK ORDER NON-CONFORMANCE (NCR WORK ORDER NON-CONFORMANCE (NCR STEP Description of NC Section A Initial Action Description Sign 8	STEP PROCEDURE CHANGE By Date :PAR #:Fault Category:NCR: Yes No DQ QA: N/C Close WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Corrective Action Section B Section A Initial Action Description Sign & Section B Section A Verifit Section B Initial Action Description Sign & Section B Section A Verifit Section B Section A Verifit Section B Section B Verifit Section B Section	WORK ORDER CHANGES STEP PROCEDURE CHANGE By Date Qty :PAR #:Fault Category:NCR: Yes No DQA: QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC	STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr E PAR #: Fault Category: NCR: Yes No DQA: Date: QA: N/C Closed: Date: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Corrective Action Section B Section C Section C Chief Eng / Prod Mgr

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	32770
	1		
Description: Lug Bracket		Part Number:	D2735-1
Inspection Dwg: D2735 Rev: C			Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	X First Article			Proto	type
Drawing	Talaranaa	Actual	Accent	Painet	Metho

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.41	+/-0.030	0,40	/		Vern	
6.594	+/-0.010	6,600	1		Vern	
R0.63	+/-0.030	R0.63			R-6	
1.750	+/-0.010	1,75			Vern	
Ø0.438	+0.006/-0.001	\$64.00			Vern	
0.75	+/-0.030	€ .75 0.24	/		tera heis	ntsage
R1.00	+/-0.030	R1.00			V2-6	
1.50	+/-0.030	1.50			Vern	
0.125	+/-0.010	6.121	/		Vern	
			-11			
				···		
					<u> </u>	,
				··		
						,

Measured by: SAD	Audited by:	Prototype Approval:	N/A
Date: 07/06/13	Date: 07/06/12	Date:	N/A

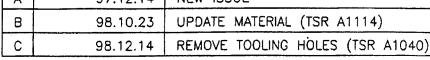
Rev	Date	Change	Revised by	Approv#d
Α	07.02.02	New Issue	KJ/JLM	
L	· · · · · · · · · · · · · · · · · · ·		· ()	

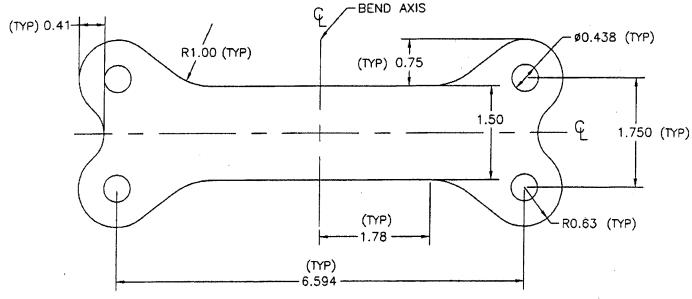




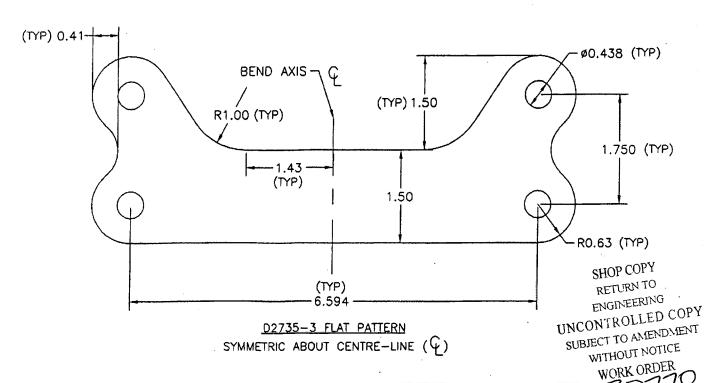
			\\\\\\			
DESIGN DRAWN BY			DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
CHECK	KED,	APPROVED	DRAWING NO.	REV. C		
ļ	(P)	KE	D2735 SHEET 1	0F.2		
DATE		<u> </u>	TITLE	SCALF.		
98.1	12.14		LUG BRACKET	2:3		
Α		97.12.14	NEW ISSUE			
В		98.10.23	UPDATE MATERIAL (TSR A1114)			

RELEASED 1881214 DS





$\begin{array}{c} \underline{\text{D2735-1 FLAT PATTERN}} \\ \text{Symmetric about both centre-lines (φ)} \end{array}$

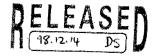


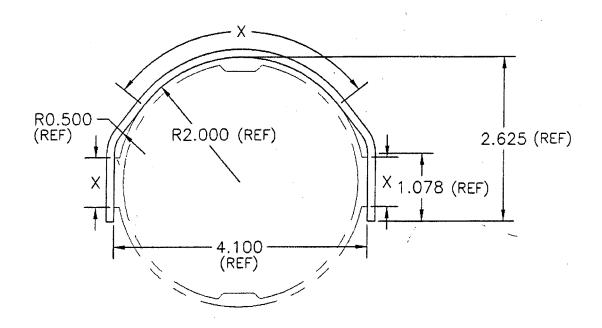
Copyright 1997 by DART AEROSPACE LTD

NO. 3770



DESIGN	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CA	
CHECKED	APPROVED KE	D2735	REV. C SHEET 2 OF 2
DATE		TITLE	SCALE
98.12.14		LUG BRACKET	2:3





D2735-1 AND D2735-3 BEND DETAIL
D2735-1 AND D2735-3 SHOULD BE BENT TO WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2500-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL

0.125 THICK (11 GAUGE)

MIN. ULTIMATE TENSILE STRENGTH = 42 ksi MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE IN INCHES

ED SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

Copyright 1997 by DART AEROSPACE LTD